

Date: Tuesday, 7/24/2007 10:49:45 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : COVER
Job Number : 33722	
Estimate Number : 12961	
P.O. Number :	Part Number : D36411
This Issue : 7/24/2007 S.O. No. :	Drawing Number : D3641 UNDER REVIEW
Prsht Rev. : NC	Project Number : AC0005
First Issue : 11 Type : SMALL /MED FAB	Drawing Revision : U/R
Previous Run :	Material :
Written By : <u>JB 07-07-24</u>	Due Date : 7/31/2007 Qty: 2 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 07-07-20 JLM	Verified By:EC

Additional Product

# PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S032	6061-T6 Sheet 0.032"
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Comment: Qty.: 0.8244 sf(s)/Unit Total : 1.6487 sf(s)  
 M6061-T6 .032" THK sheet M 16954  
 Batch: HB 07-07-30

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3641  
 Dwg Rev: PROTO  
 Prog Rev: TYPE  
HB 07-07-30  
 2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE  
HB 07-07-30

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK  
JB 07-08-02

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 Form as per Dwg D3641-1  
JB 07-08-02

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 33722

Part Number: D36411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

**ENGINEERING  
APPROVAL**

INSPECT WORK TO CURRENT STEP

07-08-04



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

N/A

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

10.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

07-08-15

Job Completion



FOR ENGINEERING USE ONLY

w/o 00104

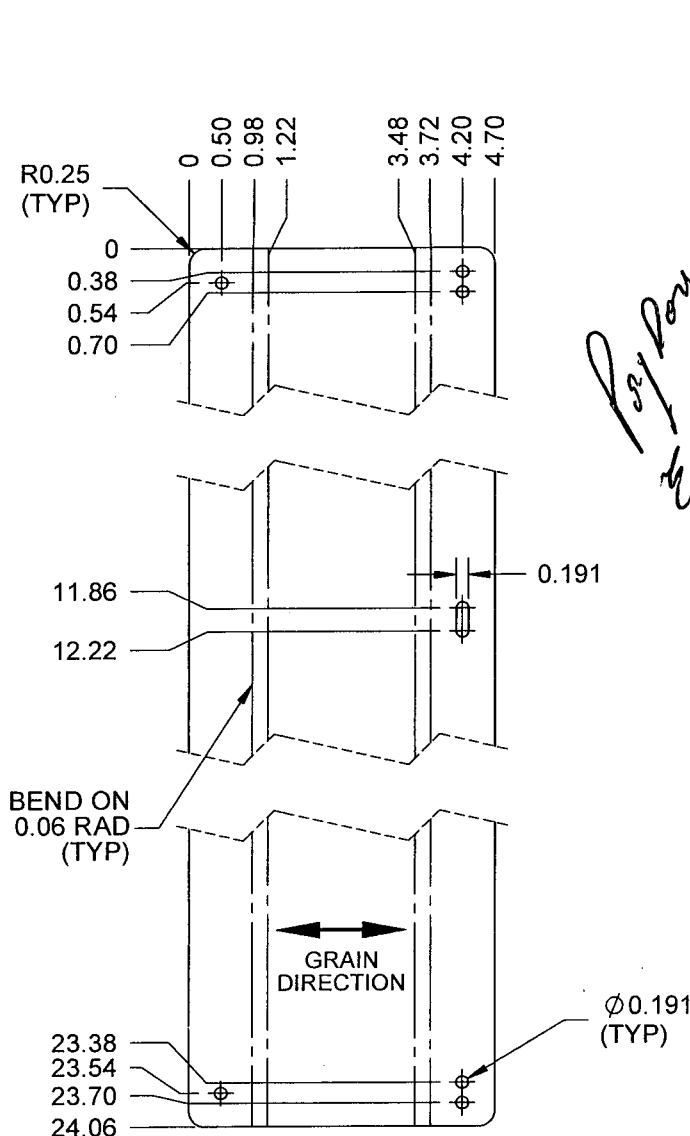
✓

07-08-15

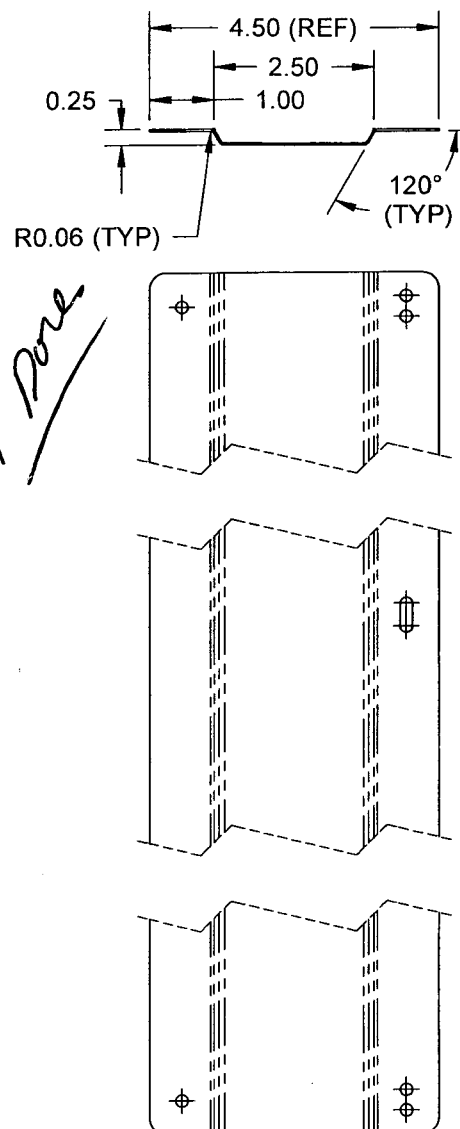
**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING

LE 07-07-17

DESIGN <b>TS</b>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED	DRAWING NO. <b>D3641</b>	REV. A SHEET 1 OF 2
DATE <b>07.06.26</b>	TITLE <b>COVER</b>		SCALE 1:3
REV A	DATE 07.06.26	DESCRIPTION NEW ISSUE; REPLACES G10606	



**D3641-1F FLAT PATTERN**



**D3641-1 COVER**  
**(REPLACES GENEVA P/N G10606-3/-6)**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM 0.032 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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